

Work Order ID 78999

78999

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Wednesday, January 18, 2012 10:41:09 AM

Item ID: D3685-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: BIPOD MOUNT ASSEMBLY
 Start Date: 1/18/2012 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 1/23/2012 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: *MF* Date: *12-01-18* Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3685	Rev D								
100	Pick Kit	0.00							
100									
Packaging	Memo	0.00							
Packaging									
110	Small Fab	0.00							
110									
Small Fab	Memo	0.00							
Small Fab	1-Use anti-seize compound Tectly 502c Class 1,Mil-PRF-16173E or equivalent on thread and assemble as per dwg D3685 2-Assemble D3684-047 & D3687-3 Using Sikaflex -241/-291 between mating surfaces as per Dwg D3685 ***Ensure holes for AN3C Bolts are free of sealant. Torque Fastners as per Dwg D3685								

SD
① / FF 12-01-31

① / FF 12-01-31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							
130 *130* Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo	0.00 0.00							
140 *140* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							

8/21/11

12/11/31

12/21/11

12/20/31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 78999

Parent Item: D3685-041

Parent Item Name: BIPOD MOUNT ASSEMBLY

Start Date: 1/18/2012

Required Date: 1/23/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue 08-02-12 DD verified by:LL
 IPP Rev:B As per Rev B 09-01-07 JLM Verified By:EC
 03-16 JLM VERIFIED BY:EC
 IPP Rev:C Added sealant note as per Rev C 09-01-20 JLM Verified By:DD
 IPP REV:C AS PER REV D 10-

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN3C12A Bolts		Purchased	No			110	Each	40.0000	4	4		FF 12-01-31	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST351		40							
				117514		4							
				118112		5							
				118422		8							
				118451		22							
				119510		1							
D3684-047 FWD LEG ASS'Y		Manufactured	No			110	Each	0.0000	1	1		FF 12-01-31	
D3684-049 AFT LEG ASS'Y		Manufactured	No			110	Each	0.0000	1	1		FF 12-01-31	
D3687-3 MOUNT		Manufactured	No			110	Each	5.0000	1	1		FF 12-01-31	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		5							
				61890		1							
				61964		4							
D3692-1 SPACER		Manufactured	No			110	Each	121.0000	8	8		FF 12-01-31	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST061		121							
				51467		21							
				73232		100							

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Work Order ID: 78999

Parent Item: D3685-041

Start Date: 1/18/2012

Required Date: 1/23/2012

Parent Item Name: BIPOD MOUNT ASSEMBLY

Start Qty: 1.00

Required Qty: 1.00

MS21043-3 Purchased No 110 Each 1,243.0000 4 4 FF 12-01-31
Nut

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FG	72	
103691	72	
ST300	632	
<u>119901</u>	632	<u>7</u>
ST301	539	
118077	2	
118614	441	
118686	30	
119758	66	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

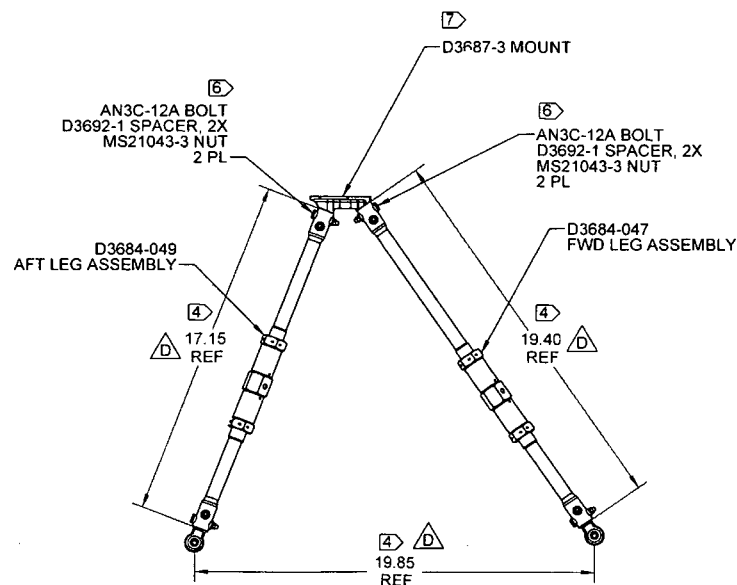
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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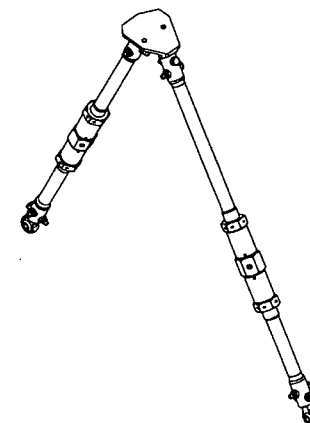
ITEM	QTY -041	PART NUMBER	DESCRIPTION
1	X	D3685-041	BIPOD MOUNT ASSEMBLY
2	1	D3687-3	MOUNT
3	1	D3684-047	FWD LEG ASSEMBLY
4	1	D3684-049	AFT LEG ASSEMBLY
5	8	D3692-1	SPACER
6	4	AN3C-12A	BOLT
7	4	MS21043-3	NUT



D3685-041 BIPOD MOUNT ASSEMBLY

NOTES:

- 1) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) UNITS: INCHES UNLESS OTHERWISE NOTED
- 3) IDENTIFICATION: IDENTIFY WITH DART ASSEMBLY P/N D3685-041 USING FINE POINT PERMANENT INK MARKER
- 4) DIMENSIONS SHOWN ARE WHEN D3688-1/3 & D3691-1 STUDS ARE FULLY THREADED INTO D3689-1 SLEEVES
- 5) WEIGHT: 6.6 lbs
- 6) TORQUE FASTENERS TO 20-25 in-lbs
- 7) ASSEMBLE D3684-047 & D3684-049 WITH D3687-3 USING SIKAFLEX-241/291 OR PROSEAL 890 OR MIL-S-8802 CLASS 'B2' SEALANT BETWEEN MATING SURFACES. ENSURE HOLES FOR AN3C BOLTS ARE CLEAR OF SEALANT



78999

RELEASED
2010-03-15

D	17.15 WAS 17.27 (ZN B6-1); 19.40 WAS 19.52 (ZN B4-1); 19.85 WAS 20.24 (ZN B5-1)	RF	10.03.03
C	NOW ASSEMBLED USING SEALANT (ZN A8-1, C4-1)	RF	08.12.15
B	19.52 WAS 19.95 (ZN B4-1); REFORMATTED TO CURRENT DWG STANDARDS	RF	08.11.24
A	NEW ISSUE	RF	08.05.22
REV.	DESCRIPTION		BY DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	#	DRAWING NO.	REV. D
MFG. APPR.	#	D3685	SHEET 1 OF 1
APPROVED	#	TITLE	SCALE
DE APPR.	#	BIPOD MOUNT ASSEMBLY	NTS
DATE	10.03.03	COPYRIGHT © 2008 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	